

Work Order ID 64666

Monday, December 13, 2010 1:08:19 PM



Page 1

Item ID: D3480-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyeball Adapter Flange

Start Date: 12/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 10-12-13 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3480	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3480**USE D3480-1 CUTTING FILE**** ☐ Dwg

304 . 018

Rev: C ☐ Prog Rev: CB10-12-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-12-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8101214

Work Order ID 64666

Monday, December 13, 2010 1:08:19 PM



Page 2

Item ID: D3480-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyeball Adapter Flange

Start Date: 12/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

Memo

0.00

0.00

1-Form as per dwg D3467 using DT8856 2-Deburr

SB 10/12/14

(2)

Deburr = 2 m-l 12/12/13 (2x)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 10/12/14

(2)

150



Packaging

Packaging

Identify as per dwg & Stock Location: 6A

Memo

0.00

0.00

SB 10/12/14

Work Order ID 64666

Page 3

Monday, December 13, 2010 1:08:19 PM

Item ID: D3480-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyeball Adapter Flange

Start Date: 12/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/15

AMF

10-12-14

Picklist Print

Monday, December 13, 2010 1:08:19 PM

Page 1

Work Order ID: 64666



Parent Item: D3480-5



Parent Item Name: Eyeball Adapter Flange


Start Date: 12/13/2010

Required Date: 12/13/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev. A 06.02.07 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA  304/316 0.018 SHEET		Purchased	No				sf	118.0400	0.08	0.160080			



810-12-13

Location

Loc Qty

Loc Code

MAT20

118.04

109398

22.04

112885

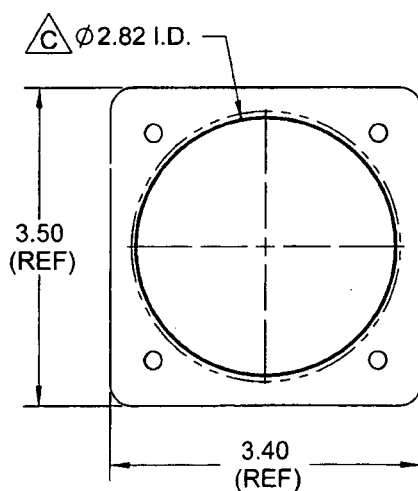
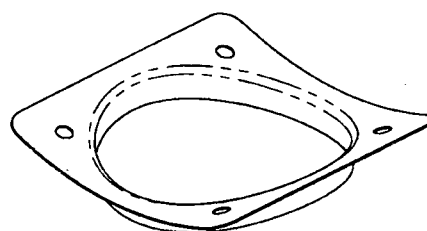
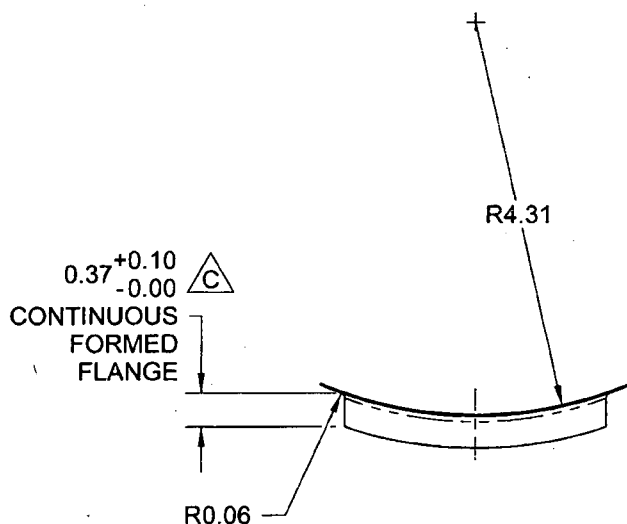
96

109398

(4)

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 5 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASED
9/6/20 MP**D3480-5 EYEBALL ADAPTER FLANGE****NOTES:**

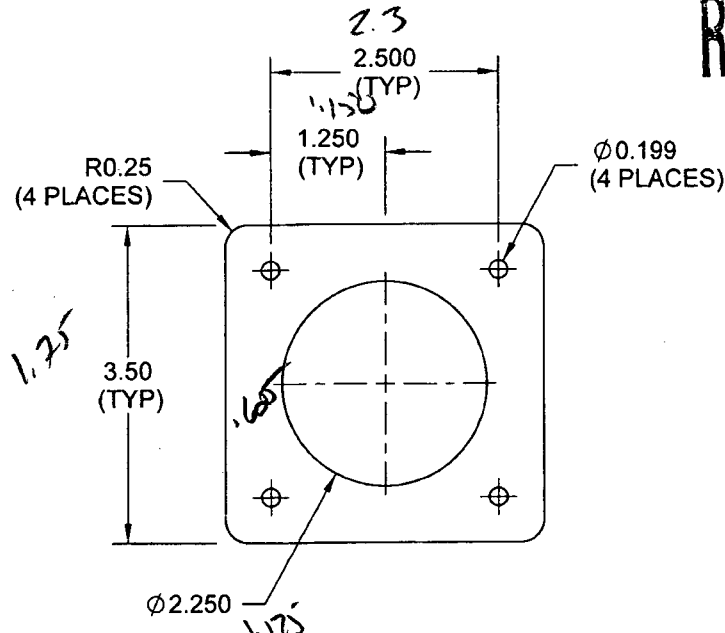
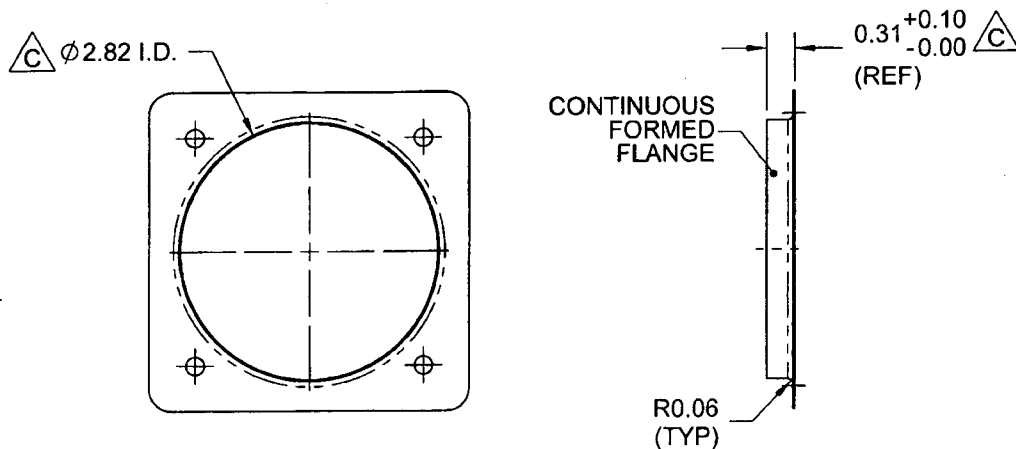
- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 3 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

**D3480-1F FLAT PATTERN****D3480-1 FLANGE**
(MAKE FROM D3480-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.